

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027861**Date Inspected:** 28-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Supplemental Procedure SE-UT-D1.5-CT-108-ESW-R3:

Approximately 7:00am the QA and QC personnel were called for a meeting at the ABF/JV conference room located at the Pier 7 facility. In addition to QA/QC personnel, also in attendance were SMR Nina Choy, SMR Aaron Prchlik, ABF Representative Bob Kick, QA Level III Robert Mertz, QA Level III Michael Foerder, QC Level III Leonard Cross, and QA Task Leader Bill Level.

At this meeting QA/QC were presented with an updated Ultrasonic Testing (UT) supplemental procedure SE-UT-D1.5-CT-108-ESW-R3 for analysis of recordable and transverse indications found in the tower shear plate Electroslog Welds (ESW). The primary focus of the supplemental was the establishment of a process that would be used to evaluate the planar characteristics and overall length and depth of observed recordable indications.

QA were informed in this meeting that further application of this supplemental procedure would be performed in tandem with QC testing personnel to ensure QA/QC concurrence of data.

This meeting ended at approximately 8:30am.

ESW C:

This QA performed UT of weld designated as ESW C in accordance with the approved supplemental procedure. This testing was performed in tandem with QC technician Scott Alder. No transverse or rejectable indications were observed at the time of testing by either QC or QA.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Results of scanning for longitudinal planar indications were found to be inconclusive. Per direction by QA Level III Robert Mertz and SMR Aaron Prchlik the area tested in accordance with this supplemental procedure will require further evaluation as a new updated supplemental procedure becomes available.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations were relevant to testing performed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
